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Nº 446.

EMPIRE RAY

RECORDS DEPT., LONDON.

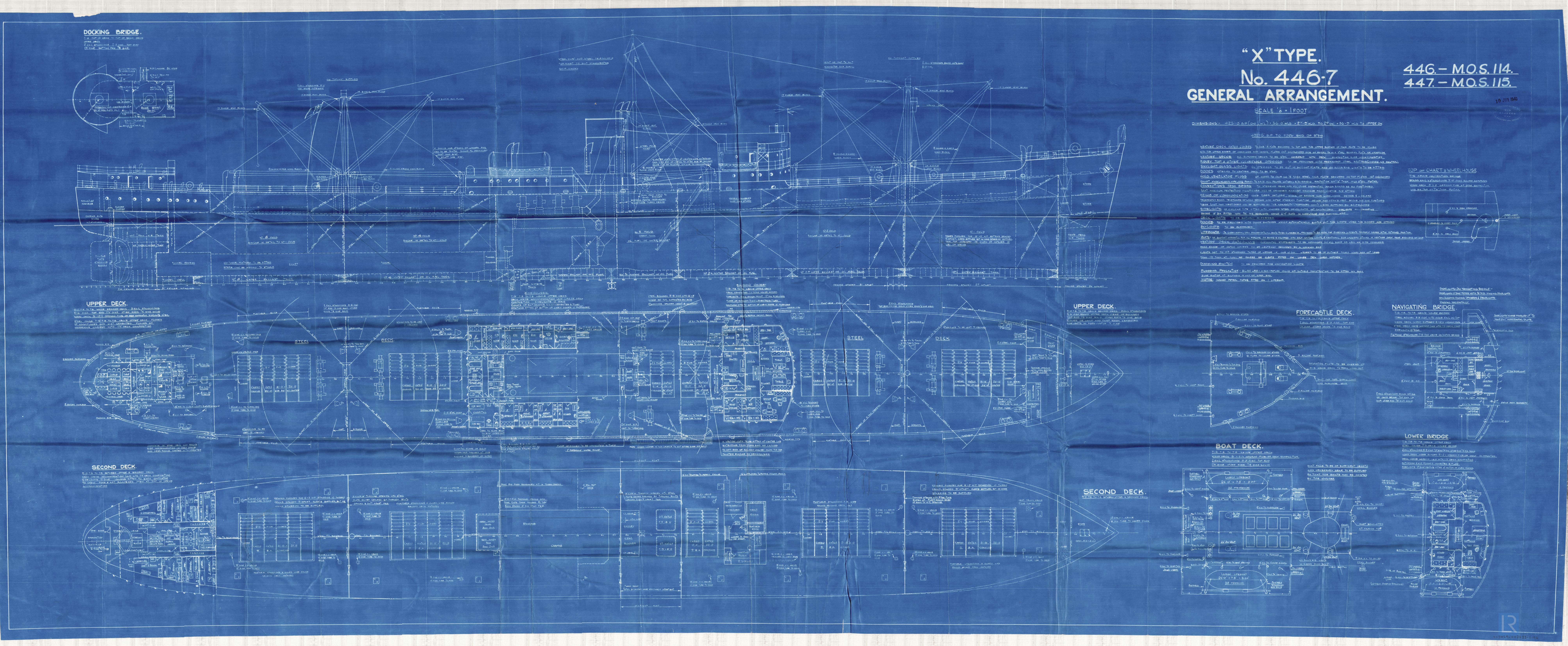


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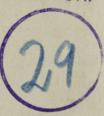
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Spofile Deck Greenock Ded.

EMPIRE RAY

1 1 STANLEY

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M.O.S. 114 & 115 M.V. EMPIRE RAY M.V. EMPIRE STANLEY PROFILE & DECKS

SCALE 1/8"=1-0"

DIMENSIONS

MLD DEPTH TO SECOND DECK 27-9"

MLD DEPTH TO UPPER DECK 36-10"

TO CLASS B. S. * WITH FREEBOARD.

SCANTLING NUMERALS

IS LONGITUDINAL NUMBER LXD = 425 x 35.75		15193.75
2 LONGITUDINAL NUMBER L(B+D) = 425(56+35.75)	STREET,	38993.75
4/D TO UPPER DECK = 425 ÷ 35.75	AND DESCRIPTION OF THE PARTY OF	11.54
D MOULDED DEPTH = 27.75 + 8	=	35.75
d = 3675 - (9+3-7/4) - 3" FOR HIGHER BKT		23.90

ALL SECTIONS INDICATED ARE N.B.S.

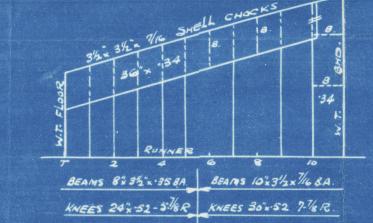
YARD NO'S FOR SHIPS ARE 446 & 447 RESPECTIVELY. SCANTLINGS

FOR BOTH ARE SIMILAR EXCEPT AT UPPER DECK BEAMS FTO 8 & 163-4

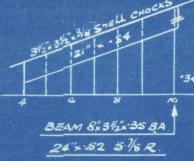
WHICH ARE 8x31/28.A. IN 447. AND AT 200 DECK BEAMS FTO T WHICH

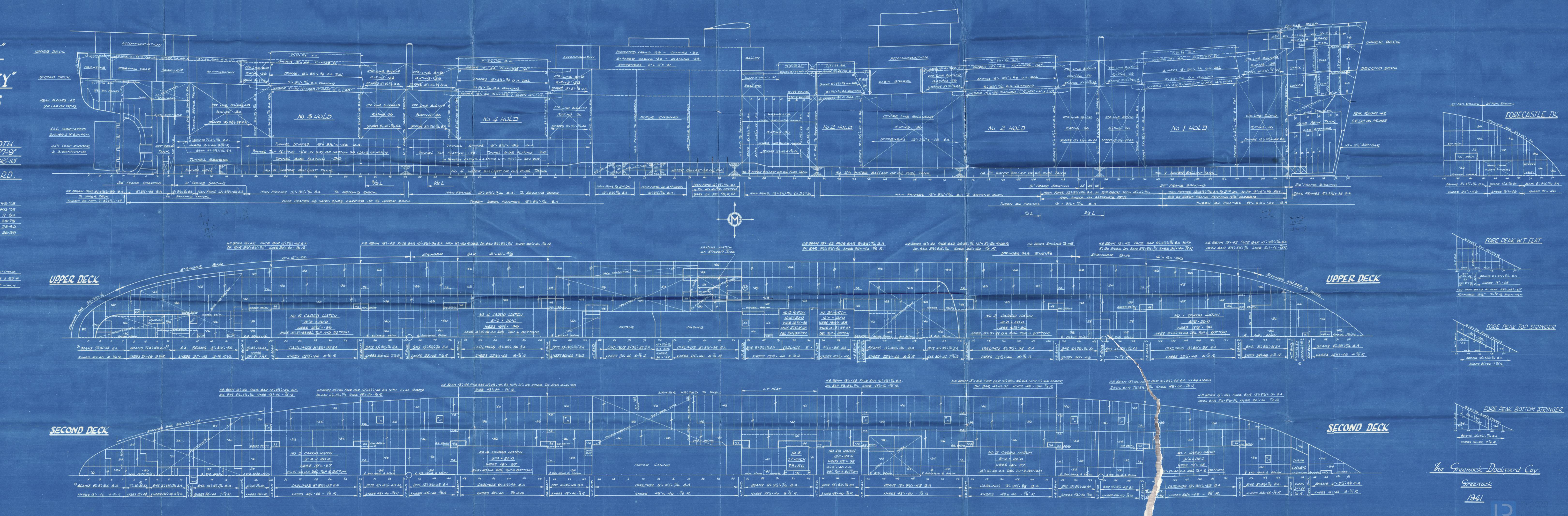
ARE 6"x31/28.A 6 1 704 WHICH ARE 8"x31/2" B.A. IN 447.

AFT PEAK TOP STRINGER



AFT PEAK BOTTOM STRINGER





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Midship Section. [as BUILT]
Los HALO-T

EMPIRE RAY

RECORDS DEPT.

(31)



3R. AT ENDS. SPRINCER ANCLE 6" × 6" × 5/8" FOR YZ LEN & TO 31/2" × 31/2" × 1/6" AT ENDS. Plating inside openings . 40 for 1/2 Len. & to .36" At ends butts Lapped and 2R. to IR. .63" ABREAST 20'-0" OPENINGS. 36 AT ENDS. 10-0 TO HEEL OF BAR '59" ABREAST 18'- O" OPENINCS. MIDSHIP SECTION. BUTTS LAPPED AND 3R. AND 2R. STEM 10" x 2/2. STERNERAME AND RUDDER FABRICATED. SCALE 1/2"=IFOOT. ON 446, CAST ON 447. STRINGER BAR 6 × 6 CARGO HATCH. BULB PLATE WELDED TO DE TO CLASS B.S. * WITH FREEBOARD. UPPER DECK BEAMS AND KNEES. 2" TUMBLE HOME DIMENSIONS: 425-0" B.P. ON LW.L. × 56-0" MLD. BOTH. MLD. DEPTH TO SECOND DECK 27-9 BEAMS FORWARD OF CHAIN LOCKER BHD. 6 x 3/2"x 5/16" B.A. KNEES 16 12" X 12" BEAMS IN CHAIN LOCKER 7 x 3"x -33" B.A. KNEES 21" x 15" BEAMS IN NO. | UPPER THN. DKS. IN WAY OF HATCH 8" 3 1/2" x 35" BA.KNEES 221/2" x 17" - FORD. OF HATCH 8" x 3 1/2" x 1/6" B.A.KNEES 24" x 17" 3 × 3 × 3/8 ANCLE AFT OF HATCH, 10" × 3/2" × 7/16" B.A.KNEES 30" × 24" MOULDED DEPTH TO UPPER DECK 36'-10" 2 · 3/4" RIVETS BEAM CAMBER 13" AT UPPER DECK. BEAMS IN NO. 2. UPPER TWN. DES. IN WAY OF HATCH 8" × 31/2" × 35 B.A. KNEES Z 21/2" × 17" - CLEAR OF HATCH FRMS. 102-109, 8"×31/2" × 35 BA. KNEES Z 21/2" × 17" FRAMES 110, 114 10" x 31/2" x 7/16" B.A. KNEES 30" x 24" SCANTLING NUMERALS. L IN 58" 137. LONGITUDINAL NUMBER LXD = 425 x35.75 = 15193 -75 BEAMS INNO 3 UPPER TWEEN DES. IN WAY OF HATCH 8 = 3/2 = 35 BAKNEES Z21/2" × 17"-CLEAR OF HATCH 9 × 3/2 × 16 BAKNEES Z21/2" × 17" .26" CENTRE DIVISION BEAMS IN WAY OF CASING B" × 3/2" × '35" BA. KNEES 24" × 17" EXCEPT 74 875 WHICH ARE 12 × 3/2" × 9/16" B.A. WITH 36" × 27" KNEES. 2ND LONGITUDINAL NUMBER L(8+2) = 425(56+35:75) = 38993 . 75 STIFFENERS 5"×3"×3/8" ON BEAMS IN NO. 4 UPPER TWN. DECKS IN WAY OF HATCH 8 x 3/2 x 35 B. A. KNEES 22/2" x 17" CLEAR OF HATCH 10"x 3/2"x 1/16" B.A. KNEES 30"x 24 SECOND DECK. = 425 = 35.75 = 11.54 D TO UPPER DECK ALTERNATE FRAMES BEAMS IN NO 5 UPPER TWN. DECKS IN WAY OF HATCH AND AFT 8" 3 1/2" × 35" B.A. KNEES 22 1/2" × 17" FORD. OF HATCH 10" × 3 1/2" × 116" BA. KNEES 30" × 24" =27.75 + 8 = 35.75 D MOULDED DEPTH STRINCER PLATE 72" x . 40" FOR YZLEN & TO . 34" AT ENDS. BUTTS LAPPED AND ZRL ATCH END STIFFENERS BRACKETED AFTER BEAMS FRAMES C-T. 7 3" x 38" BA.KNEES 21" x 15" - FRS. 1-8 7" 3" x 33" B.A.KNEES 21" x 15" 1- FRMS. 9-17 8" x 31/2 x 35 BA.KNEES 24 x 17 d =36.75 - (9+3.7/4) -3" FOR HICHER BKT. = 23.90 PLATING ABREAST OPENINGS 36" FOR 1/2 LEN M. 18 × 18 TOP AND BOTTOM. THESE BEAMS DO NOT INCLUDE HATCH BEAMS WHICH ARE IS" DEEPWITH BA. FACE BARS (SEE PROFILE & DECK) KNEES 30" 30" = 26.39 d at half length forward. PLATING INSIDE LINE OF OPENINGS 34 TO 30 AT ENDS. BUTTS LAPPED AND ZR. TO IR, AT ENDS. WARPS 90 FATHOMS 3" FLEXIBLE STEEL WIRE GN12 K OUT 58" 10'- 0" TO MEEL OF DECK BAR NOTE: - YARD NOS. FOR SHIPS ARE 446 & 447 RESPECTIVELY SCANTLINGS FOR BOTH ARE SIMILAR EXCEPAT UPPER SECOND DECK BEAMS AND KNEES Stringer plate tack welded to shell, N4 × 144° Square light tack welded to da BEAMS FORWARD OF CHAIN LOCKER BULKHEAD 6" x 31/2" x 3/8" O.A. KNEES 18" x 15" BEAMS IN NO. I HOLD IN WAY OF HATCH 8 x 3 1/2 x . 35 BA, FORD. OF HATCH 8"x 31/2" x 1/16" BA.KNEES 50" x . 43". AFT OF HATCH WHICH ARE 8 +3 2 BA. IN 4 47. 12" 3"2" × -45" BA. KNEES 48" × 27". BEAMS IN NO. 2 HOLD IN WAY OF HATCH 9" x 31/2" x 3/8" B. A. - CLEAR OF HATCH 12" x 3/2" x 45 B. A. KNEES 48" x 27" BEAMS IN NO. 3 HOLD (DEEPTANK) 8" × 31/2" × 7/6" B.A. KNEES 331/2" × 27" 3" × 3" × 3/8" ANGLE KEEL BUTTS: - 4R.I" RIVS. 4 DIAS. APART, 14" BUTTS. 3R. I" RIVS. 31/2 DIAS. APART, 10/2" BUTTS. CENTRE CIRDER BUTTS 3R. 1/8 RIVS. SPACED 4 DIAS. APART. BEAMS IN WAY OF CASING 8 . 31/2 . 1/16 8.4. KNEES 48 . 27" 4-3/4" PINETS, BULKHEAR TANK FRMS. TO SHELL TO SHELL TO SPACED 5/2045. APART FORD Y LEN. FORD. AND TOIAS. APART AFT 12 LEN. FORD. BEAMS IN NO. 4 HOLD - IN WAY OF HATCH 9" x 31/2" x 3/8" B.A. CLEAR OF HATCH 12" x 31/2" x .45" BA. KNEES 48" x 27" NELDED TO BEAMS CLEAR BEAM CAMBER 14" AT 2ND. DECK. BEAMS IN NO 5 HOLO "IN WAY OF HATCH &" 312" + 35" BA. FORD. OF HATCH 12" x 312" x 45" BA. AFT OF HATCH 10" x 312" x 50" BA. KNEES 48" x 27" OF STIFFENERS. " REVERSE FRAMES BOTH FLANCES CLEAR OF MOTOR & BOILER SPACE & W.T. & OT. FLOORS TO RIVE SPACED T DIAS. APART CR. TO CR. AFTER BEAMS - FRS. C-4. 6 x 3 x 34 BA FRS. 114 7 3 x 3/8" BA. KNEES 21" x 15" FRS. 5-10 8" x 3/2" x 7/6" BA. KNEES 24 x 17" FRAMES 12 - 17 " FRAMES & REVERSE FRAMES ON W.T. & O. T. FLOORS. " B DIA. SPACED & DIAS APART CR. TO CR. 10" × 31/2" × 1/16 84 KNEES 30" × 24" REVERSE FRAMES TO HEAVY MOTOR SEAT PLATES 148" DIA. SPACED 4/2 DIAS. APART CR. TO CR. THESE BEAMS DO NOT INCLUDE HATCH END BEAMS FOR THESE SCANTLINGS SEE PROFILE & DECKS. J IN 78" " FLOORS IN MAY OF HEAVY PLATING IN MOTOR & BOILER SPACE 1/8" DIA. SPACED 41/2 DIAS. APART CR. TO CR. BOTH FLANCES IN MOTOR & BOILER SPACE CLEAR OF SEATING 1/8" DIA. SPACED 1 DIAS. APART CR. TO CR. FORECASTLE DECK PLATING BEAMS & KNEES. TANKTOP BUTTS 1/8 RIVS. SPACED 31/2" APART OR. TO CR. MARCIN PLATE BUTTS 1/8 RIVETS SPACED 4 DIAS. APART CR. TO CR. STRINGER PLATE . 36" THK. DK. PLATING . 32" THK. EXCEPT IN WAY OF HAWSE PIPES WHERE IT IS . SO THK. SEAMS & BUTTS IR. 514" D.R. BEAMS 157-161 8" × 31/2 × 7/6 34. KNEES 24" × 17" + 163 + 168 7" × 3" × 3/8 84. KNEES 21" × 15" 169 - 174 6" × 31/2" × 7/6" B.A. KNEES 18" × 16". FRAMING DETAILS 4FT AND 1/2 LENGTH FORWARD WHERE THEY ARE 4R. ALSO STRAKES IN WAY, FOLE. (M &N). AND BULWARK WHERE THEY ARE IR. FRAMES SPACED 31" APART, 27" FORWARD \$15 LEN. 24" IN FORE AND AFT PEAKS. 3R. AND IR. BUTTS 78 RIVS. SPACED 31/2 DIARS. APART CR. TO CR. 4 R. BUTTS 78" RIVS. SPACED 4 DIAS APART CR. TO CR. MAIN FRAMES ABAFT '2 LEN. FORD. 12"x 31/2" = 9116 BA. TO SECOND DK. ON EVERY FRAME. BULWARK SEAMS 1/8 RIVS. SPACED & DIAS. APART OR TO CR. BULWARK BUTTS 1/8 RIVS. SPACED 4 DIAS. APART CR. TO CR. SHELL PLATING. CLEAR OF TUNNEL RECESS AND AFT DEAK WITH TWEEN DECK FRAMES 6" 31/2" 1/6 8.4. SEAMS OF SHELL PLATING (R) EXCLUDING RIVET IN FRAME :- 6 78" RIVS. IN 24" FRAME SPACING. KEEL PLATE \$2"x . 78" FOR 3/5 LEN. & TO . 68" AT ENDS BUTTS LAPRED AND 4R TO 3R AT ENDS. SCARPHED 15" TO MAIN FRAMES AT SECOND DK. AND CARRIED TO UPPER DECK ON 30 CENTRE DIVISION BOTTOM SHELLT-STRAKES A.TO E. 'G3" FOR 12 LEN. & TO 'SO" AT ENDS BUTTS LAPPED AND 4 R. TO 3R. 8 7/8" " 29,30,31" SEE PROFILE & DECK PLAN SIDE SHELL STRAKES F TO J. 62 FOR YZ LEN. & TO 46"AT ENDS BUTTS LAPPED AND B.R. FRAMES IN BOILER ROOM 12" x 3/2" x 9/16" BA. WITH A" X 4" x 9/16" REV. BAR ON ALT. FRAMES FOR SCANTLINGS OF STIFFRS FRAMES TO SHELL TERINS. SPACED 61/2 DIAS. APART CR. TO CR. 51/2 DIAS IN FORE AND AFT PEAKS DEEP FRAMING FORD, & DEEP TANK & . H OUT 78" STRAKE BELOW SHEERSTRAKE (K) + 64" FOR YZLEN. M TO . 46" AT ENDS BUTTS LAPPED AND 4R FOR 1/2 LEN M TO 3R AT ENDS FRAMES IN FORE DEAK 8 " 31/2 " 35 S.A. TO FORECASTLE DECK EVERY FRAME OUT atch end stiffre 30"×30" Bkt at 2nd Dk. FRAMES TO FLOORS AND CROSS TIE PLATES IN AFT PEAK 1/8" RIVETS SPACED & DIAS. APART CR. TO CR. SHEERSTRAKE (L) 69" FOR 1/2 LEN. & TO . 46" AT ENDS. BUTTS LAPRED AND 4R FOR 1/2 LEN. & TO 3R. AT ENDS 30" × 2512" BRACKET TO TANK TOP :30" VERTICAL SHELL FLANCE OF W. T. BULKHEAD FRAMES 7/8" PIVS. SPACED S DIAS. APART. CR. TO CR. FORECASTLE SIDES:(M) STRAKE : 40"TO 60" FORD. N STRAKE : 40" BUTTS LAPPED AND IR. BULWARK : 28" BUTTS LAPPED AND IR. FRAMES IN AFT PEAK 8" × 31/2" × 35" B.A. (FRMS. 9, 10, 11, ARE 1/16") TO SECOND DK. (N.T. FLAT.) IN.T. BULKHEAD SEAMS AND BUTTS, IR 3/4" RIVS, SPACED 33/8" APART CR. TO CR. STIFFENERS 3/4" RIVS, SPACED 51/4" APART CR. TO CR. THICKNESS OF STRAKES ATO C. FROM FORD OF 12 LEN, FORD, TO RULE POSITION OF COLLISION BULKHEAD '63"+ 10% = '69! EVERY FRAME WITH 6 - 31/2 - 1/6 B.A. THEEN DK. FRAMES BRACKETED AT SECOND DECK STIFFENERS WHERE ON LAP 3/4" RIVE SPACED 33/8" APART OR TO OR. AND CARRIED TO UPPER DK. FRAME AND BOUNDARY BAR TO BULKHEAD 3/4" RIVS. SPACED 3 1/8" APART CR. TO CR. MAIN FRAMES IN WAY OF TUNNEL RECESS 10 x 3/2 x 50 84. ON EVERY FRAME TO 2NO. DK. BOUNDARY BAR TO UPPER DK. & TANK TOP 78 RIVE. SPACED 43/8" APART CR. TO CR. BOUNDARY BAR TO ZNO. DK. 3/4" RIVE. WITH G" × 3/2" × "IG" BA. THEEN DECK FRAMES. TANK TOP CENTRE STRAKE 59 * 52" FOR 12 LEN & TO 44" AT ENDS . 52" INMOTOR ROOM BUTTS LAPRED AND 3R. TO 2R AT ENDS. SPACED 33/4" APART CR. TO CR. MAIN FRMS. FORD 1/2 LEN. FORD CLEAR OF DEED FRAMING 12" × 31/2" × 9/16" BA. WITH. TANK TOP PLATING .44" FOR 1/2 LEN MIDSHIRS TO . 40 AT ENDS PLATING '08 HEAVIERIN WAY OF HATCHES '52 IN ES. '58" IN 85. 2ND. DK. STRINGER BUTTS 2R. 3/4" RIVE SPACED 25/8" APART CR. TO CR. PLATING BUTTS I RE ZR. 3/4" RIVE SPACED 3" APART. 4" 4" 4" 4" REVERSE BAR ON EVERY ALTERNATE FRAME TO ZND. DK. TWEEN OK. BUTTS LAPPED AND ZR. SEAMS LAPPED AND ZR. TANK MARCIN ANCLE 4" 4" " 50" WINC BRACKETS : 44" 54 IN 88. " SEAMS 3/4" RIVS. G AT 24" FRM. SPACING 747 27" AND 28" FRM. SPACING 84T 29" 30, 8 3/" FRM. SPACING EXCLUDING BEAM PIVETS FROMES 6" × 312" × 1/16" BA. MARCIN CONNECTION 6/2"x 6/2"x 625" T. BAR CUSSET PLATE . 42" .52" IN B.S. TANK MARCIN PLATE . 54" .60" IN B.S. UPPER DK. STRINGER BUTTS 3R.84R. 78 RIVS. SPACED 3"APART CR. PLATING BUTTS IR. 2R. 83R. 78 RIVS. SPACED 3"APART MAIN FRAMES IN WAY OF DEEP FRAMING FORWARD 10% ABAFT COLLISION BULKHEAD " SEAMS 1/8" PIG. SAT Z4" FRM OPACING GAT Z7" & 28" FRM. SPACING THE 29", 30" & 31" FRM. SPACING EXCLUDING BEAM RIVE. (SEE PROFILE & DECKS) 12" x 3/2" x 9/16" BA WITH 6" x 6" x 5/8" REVERSE BAR DOUBLE BOTTOM. FOLE DECK STRINGER BUTTS I.R. 3/4" RIVE. SPACED 25/8" APART CR. TO CR. PLATING BUTTS IR 3/4" RIVE, SPACED 3" APART. FORMING 13/2" CIRDER ON EVERY FRAME TO ZND. DECK, TWEEN DECK FRAMES CENTRE CIROLR 4314" x .54" FOR 12 LEN. A TO . 46 AT ENDS BUTTS LAPPED AND 3R. G IN 781/2 " SMMS 3/4" RIVS. G AT 24" FRM. SPACING, 7 AT 27" FRAME SPACING EXCLUDING BEAM PINETS. 8" 31/2 " 35" BA TO UPPER DK. EVERY FRAME AND CONTINUED TO FORECASTLE FLOOR PLATES . 42' IN HOLOS AND ENCINE SPACE . 52" IN BOILER SPACE WATERTICHT FLOORS . 50" DECK BETWEEN FRAMES 157 & ILI INCLUSIVE. MOTOR SEATING CIRDERS . 75" WIERCOSTAL CIRDERS . 38" - 50" IN WAY OF MOTOR CASING. ALL MAIN FRMS. CONTINUED TO UPPER OK. IN WAY OF NATCH END BEAMS. ANCLE BOTTOM FRAMES ON SOLID FLOORS 31/2" × 31/2" · 437" AFT 1/2 EEN. FORD. FRMS. IN HOLDS AND TWEEN DECKS PUNCHED FOR SPARRING BUT NO ANCLE BOTTOM REVERSE FRAMES ON SOLID FLOORS 312" 312" 437. 4 4 - 50" IN BOILER SPACE SPARRING FITTED. SKELETON FLOOR FRAMES AND REVERSE FRAMES 6" 3/2" × 7/6" B.A. CENTRE CIRDER BOTTOM ANGLES 4 x 4" "56" TO '50" NOTE :- FRAMES PUNCHED FOR SPARRING BUT CENTRE CIRDER TOP ANGLES 4×4"× 50" CENTRE VERTICAL ANGLES 3/2 + 3/2 + 1/6 SINGLES "×5" × 50" AT THRUST AND IN ENDINE ROOM. MOTOR SEATING CIRDERS TOR ANCLE 6" 6" 6" 69 BOTTOM ANCLE 4" 4" 9/16" VERTICAL ANCLES 31/2" 31/2" 7/16" NO SPARRING FITTED. N.T. FLOOR STIFFRS. 6" - 3/2" > 3/8" OA. SPACED 30"APART. INTERCOSTAL TOP BARS 31/2" 437" SHELL CHOCKS 31/2" 437." 11'-11/2" OFF & TO WEEL OFFTOP ANGLE. INTERCOSTAL VERTICAL ANCLES 3" × 3" × 37 8" × 31/2" × 7/6" BA. TO SKELETON FLOORS. F OUT 78/2 DISPOSITION OF FLOORS " SOLIO FLOORS ON EVERY FRAME IN MOTOR SPACE AND FORD. 3/5 LENGTH FORD. AND UNDER BULKHEADS ESEWHERE SOLID FLOORS ON EVERY THIRD FRAME. BRACKET FLOORS INTERMEDIATE. G O OFF & TO HEEL OF TOP ANCLE. STIFFENERS WELDED TO TANK TOP 3 - 1/8" RIVETS IN WAY 3'-1" OFF & TO H.O.B. OF DEEP FRAMING. 11'-11/2" TO INTERCOSTAL CIRDER 4 × 4 × · 40 ANOLE 3"x3"x 3/8" ANG. ON TUNNEL TOP 2.84" 4.0" 4-0/8" 4-278" 10" 4-23/4" 2.81/4 REVERSE FRAME 6" × 6" × .50." 0.4. cusset welded to marcia SINCLE.) <u>312" × 312" × 437"</u> 31/0" x 31/0" x . 137" | 15 mm 5-18 PIVS. E IN 80 8'x 312' × 16 34. 10" x 3/2" x 1/6" BA. STRUT 23"×6"MH. 23" × 16 MM. 23"×16"MH. 6. 1/8 RIVS. 3/2" x 3/2" x . 437" SINGLE. 312"×312"× 437" BOUT 70" CIN 692" BOUT 69/2" BILCE REEL 10" x .625" BULB PLATE WELDED TO SMELL. YARD NOS. 446 & 447 M.O.S. 114 & 115 LOOKING AFT. CREENOCK DOCKYARD CO. LTD. GREENOCK 1941.

UPPER DECK.

STRINGER PLATE 66" x 66" FOR Y2 LEN. X TO 42" AT ENDS. BUTTS LAPPED AND 4R. TO

M.V. EMPIRE RAY & EMPIRE STANLEY.

28 OWER ANCHORS 68 CHTS. EACH STOCKLESS I STREAM ANCHOR - 19 CWTS. EX - STOCK. 225 FATHOMS 25/16 STUD CHAIN CABLE GOOCHTS. 90 FATHOMS 5" FLEXIBLE STEEL WIRE 6 x 12 120 FATHOMS 43/4" SPECIAL FLEXIBLE STEEL WIRE 6 x24 2 Hawsers go fathoms 23/4" Flexible Steel Wire 64/2

DECK BEAMS F TO 8 & 163-4 WHICH ARE 8 +31/2 BA. IN 447 AND AT ZNO. DECK BEAMS F. TO T. WHICH ARE 6 x31/2 BA. & 1704

TANK TOP SEAMS :- IN WAY OF 31" SPACING 7/8" RIVETS SPACED 34/9 APART CR. TO CR. IN WAY OF 27" SPACING 1/8 RIVS. SPACED 34/8 APART CR. TOCK ALL SHELL BUFFS BR EXCEPT BOTTOM SHELL (STRAKES 4. TO E) SHEERSTRAKE AND STRAKE UNDER STRAKES K RL BETWEEN YOLENOTH

SOLID FLOOR IN E.R. CLEAR OF LUB. TANK & O.T. FLOORS.

"KING ALFRED

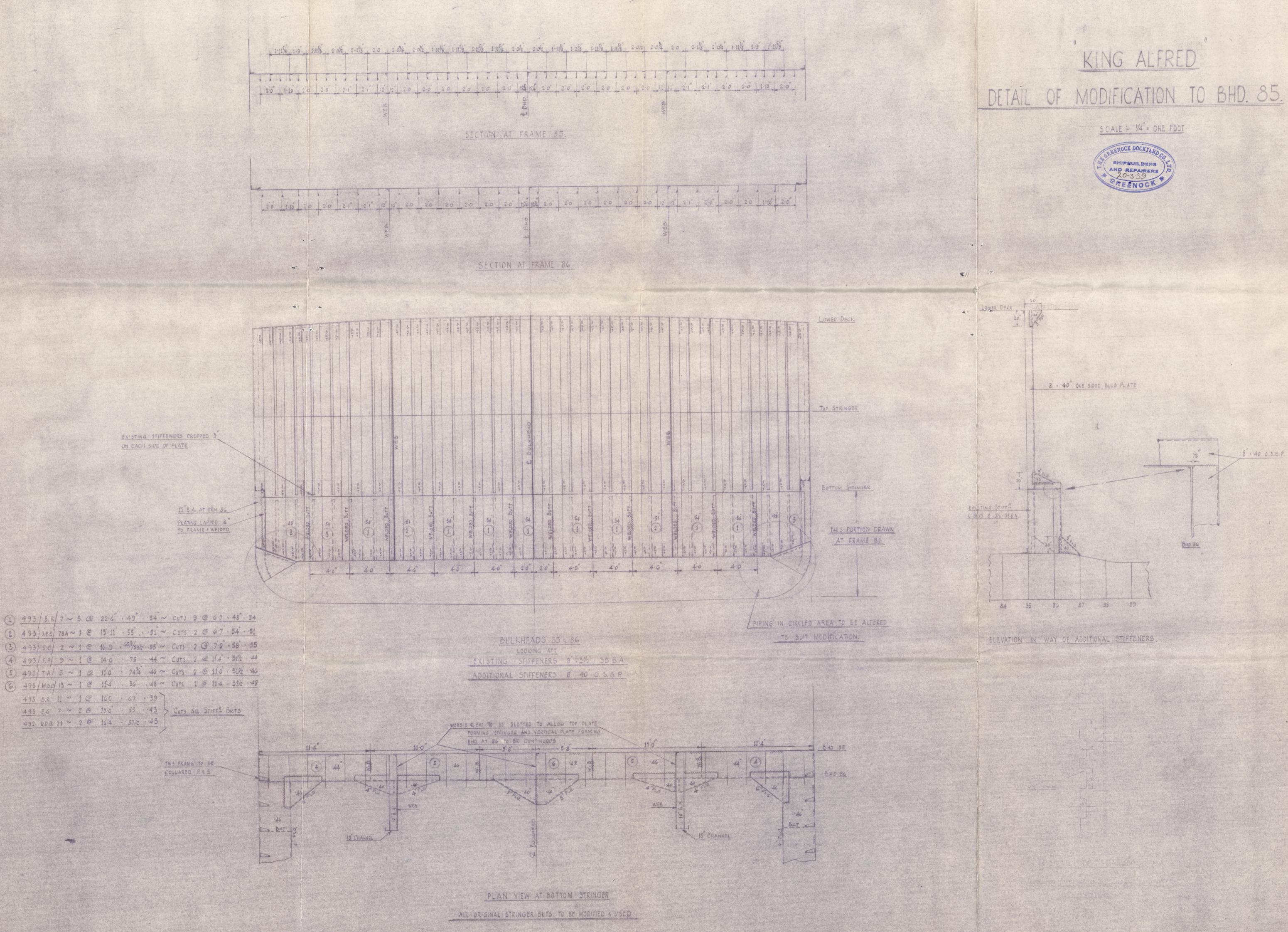
MODIFICATION TO BULKHEAD 85

CARRIED OUT AT 5.5. (e) 3/59.

GREENOCH REPORT Nº 26342.

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Habricaled Sternframe

Greenoch Bhd. Co.

Nos HHP-7

COPY OF PLAN APPROVED. 27.5.40.

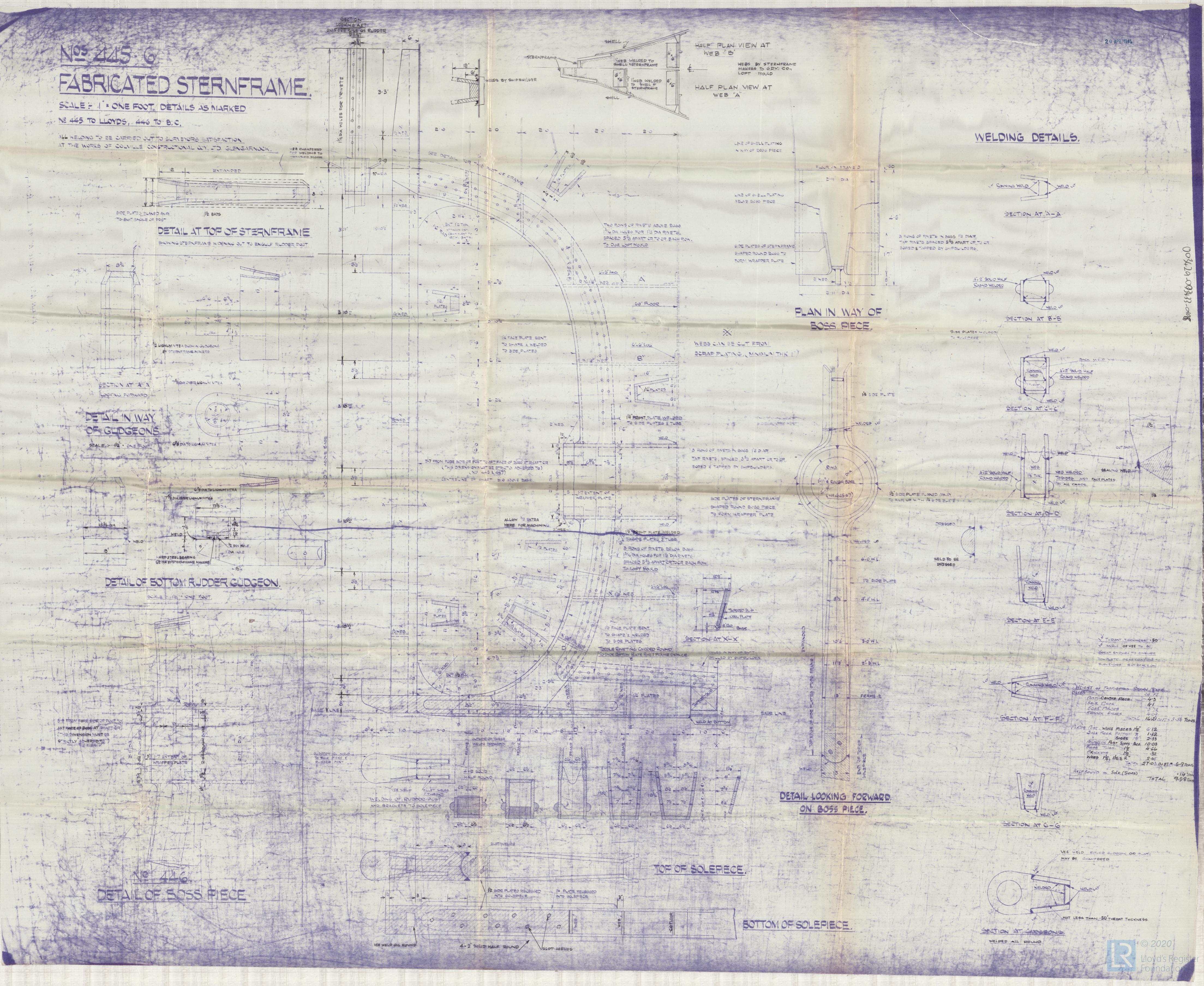
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